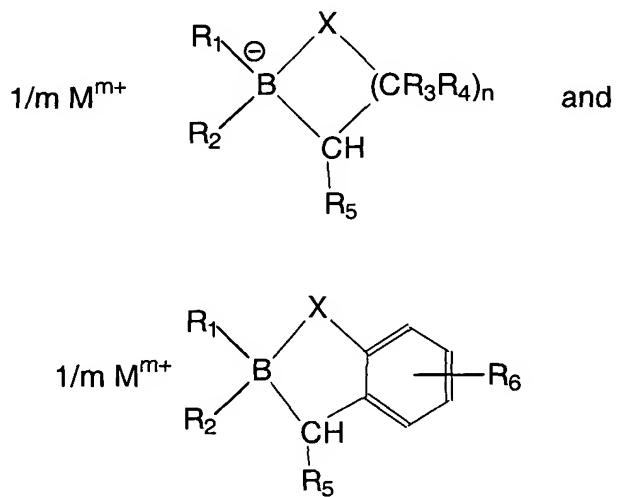


**Abstract of the Disclosure**

[0077] Disclosed are internally blocked borates useful for polymerizable compositions, and polymerizable adhesives made therewith. The internally blocked borates have general structures:



wherein X represents  $-\text{CHR}_6-$ , oxygen or sulfur; n is an integer; R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>4</sub>, R<sub>5</sub>, and R<sub>6</sub> are independently selected, for example, from unsubstituted and substituted C<sub>1</sub> – C<sub>10</sub> alkyl, alkylene groups, or aryl groups, including other embodiments further defined, and M is a counter ion with positive charge m.